

Work Order ID 65886



Page 1

Wednesday, January 26, 2011 1:55:09 PM

Item ID: D4274-3

Accept



Setup Start



Revision ID:

Item Name: Plate, Aft Support

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-01-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4274

DBT Rev. B

E 11.01.31

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

1311-2-2

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-2-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start



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Stop



Item Name: Plate, Aft Support

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



8/10/03

QC

Memo

0.00

Quality Control



130

Identify as per dwg & Stock Location: 137

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-02-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 1:55:16 PM

Page 1

Work Order ID: 65886

Parent Item: D4274-3

Parent Item Name: Plate, Aft Support



Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

65.2003

0.357

1.503158

2.5



11-2-2

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT

65.2003

114799

0.5003

116437

0.7

116623

64

116623

6

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DART AEROSPACE LTD		Work Order: 65883
Description: PLATE AFT Support		Part Number: D4274-3
Inspection Dwg: D4274-3, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	✓		V	
Ø .191	+ .006 - .001	.192	✓		V	
Ø .256	+ .006 - .001	.251	✓		V	
Ø .53	+ .008 - .001	.529	✓		V	
4.25	± .030	4.257	✓		V	
1.02	± .030	1.021	✓		V	
3.83	± .030	3.827	✓		V	
.310	± .010	.311	✓		V	
.750	± .010	.752	✓		V	
7.05	± .030	7.061	✓		V	
.92	± .030	.925	✓		V	
5.91	± .030	5.928	✓		V	
8.95	± .030	8.935	✓		PROWS	
2.88	± .030	2.798	✓		V	
1.05	± .030	1.053	✓		V	
.60	± .030	.603	✓		V	
1.20	± .030	1.208	✓		V	
1.10	± .030	1.093	✓		V	
.75	± .030	.753	✓		V	
3.000	± .010	3.000	✓		V	
1.500	± .010	1.502	✓		V	
2.300	± .010	2.301	✓		V	

Measured by: AB
Date: 11-2-2

Audited by: S
Date: 11/2/03

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A4		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 65883
Description: PLATE AFT SUPPORT		Part Number: D4274-3
Inspection Dwg: D4274-3, Rev: B		Page 1 of 1

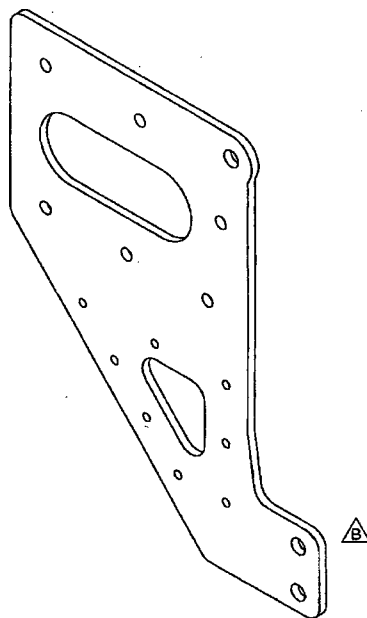
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

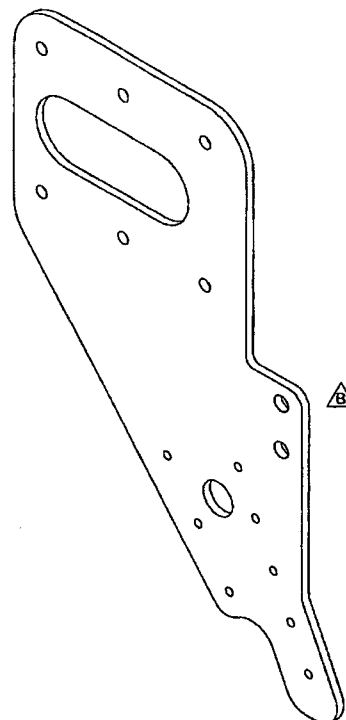
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.367	$\pm .010$	1.368	X		✓ 186	
.36	$\pm .030$.36	X		✓	
.792	$\pm .010$.792	X		✓	
.672	$\pm .010$.672	X		✓	
.464	$\pm .010$.464	X		✓	
.70	$\pm .030$.70	X		✓	
3.000	$\pm .010$	3.001	X		✓	
.750	$\pm .010$.753	X		✓	
.68	$\pm .030$.683	X		✓	
.38	$\pm .030$.382	X		✓	
1.123	$\pm .010$	1.121	X		✓	
1.983	$\pm .010$	1.983	X		✓	
.991	$\pm .010$.993	X		✓	
.125	$\pm .010$.118	X		✓	

Measured by: AB	Audited by: S	Prototype Approval:
Date: 11-2-2	Date: 11/2/03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65886

PH 11-01-26

RELEASED
R 2010-08-06

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

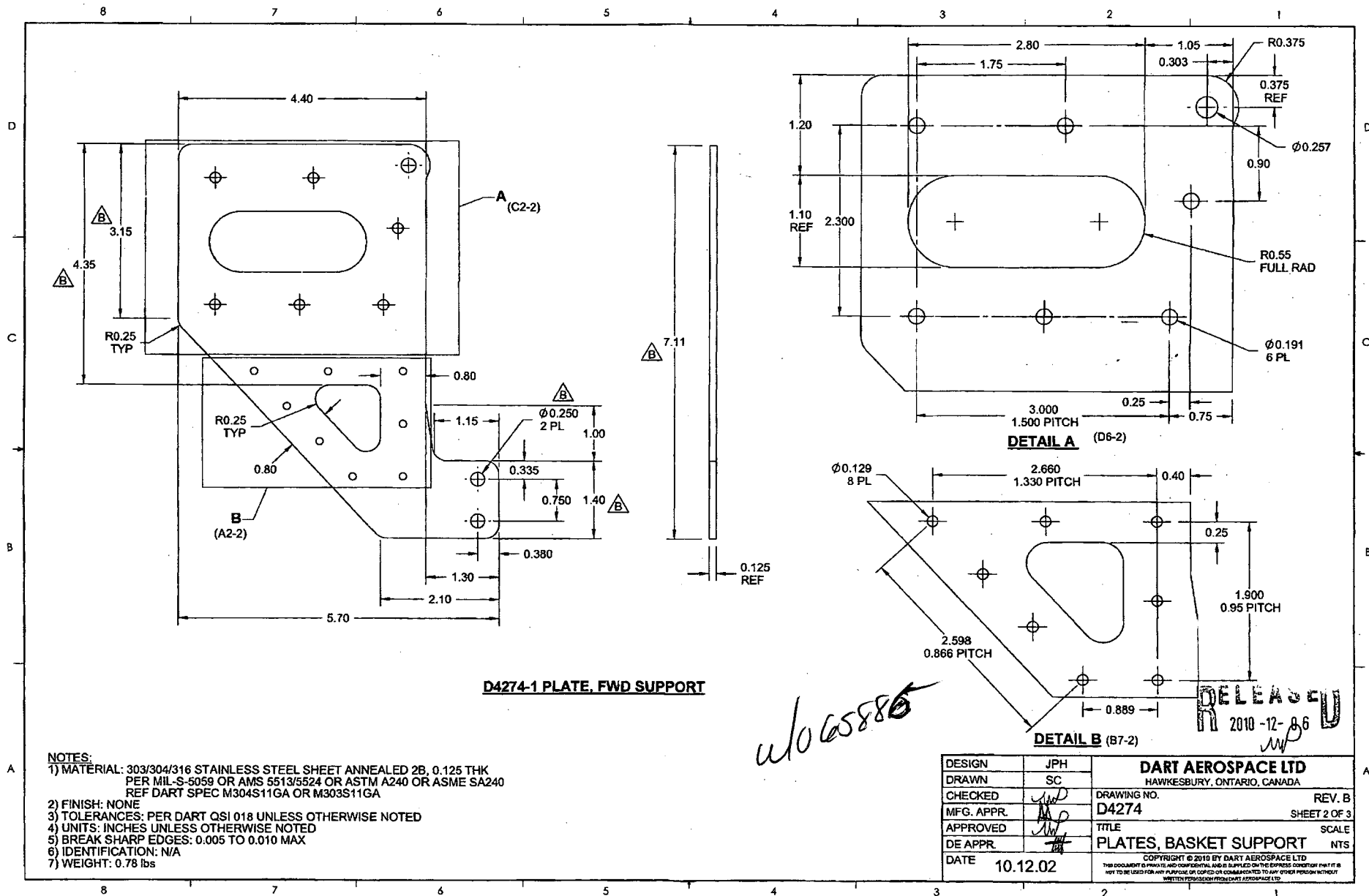
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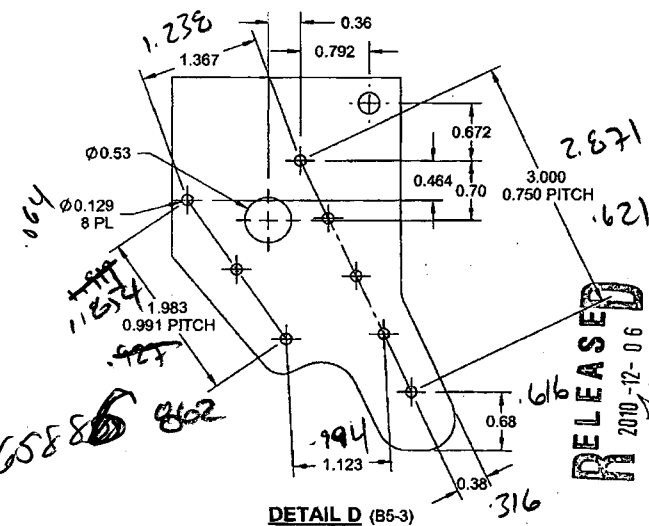
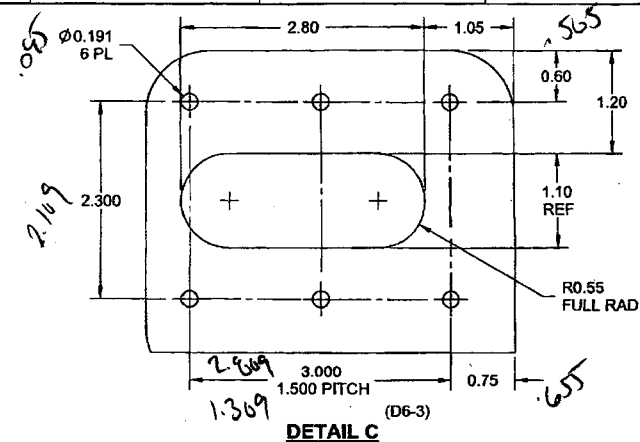
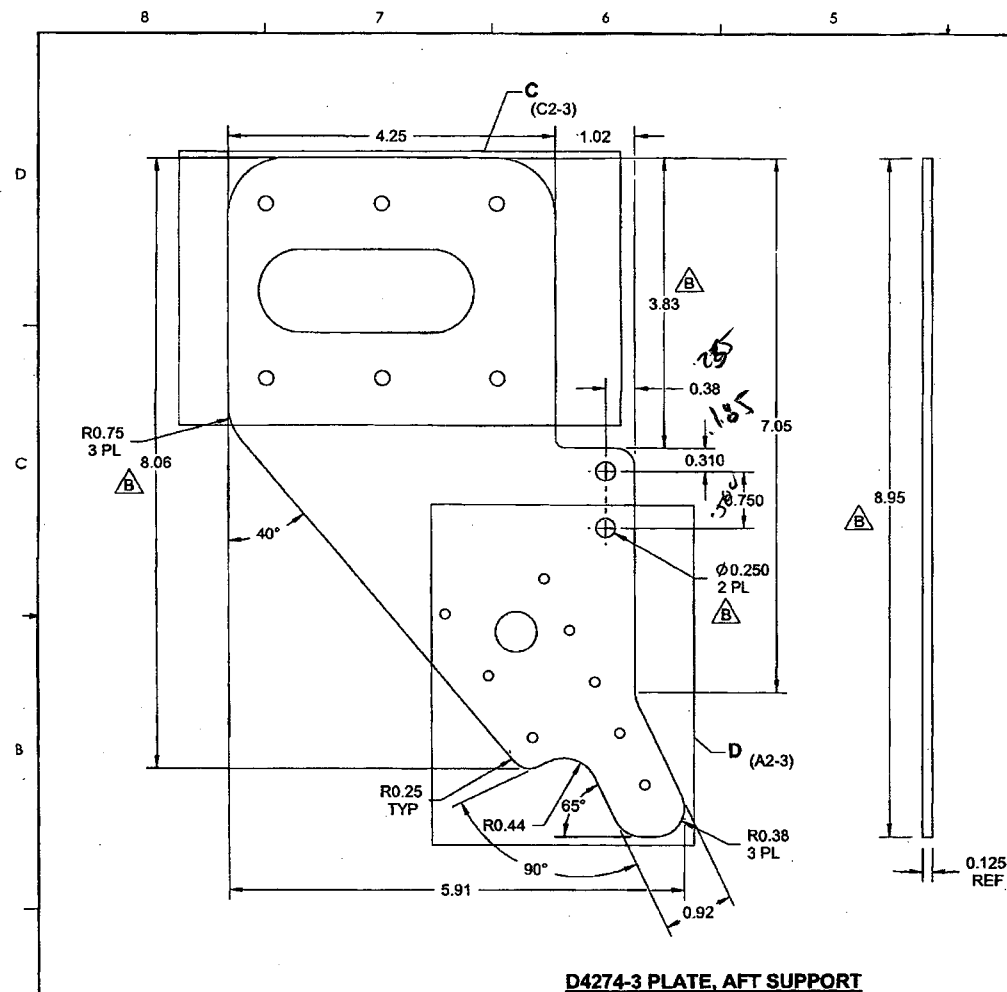
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NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.97 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WJS	DRAWING NO.	REV. B
MFG. APPR.	WJS	D4274	SHEET 3 OF 3
APPROVED	WJS	TITLE	SCALE
DE APPR.	WJS	PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-12-06

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